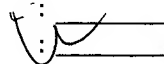


Date: Wednesday, 11/04/2007 8:57:10 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D3537-1
Job Number : 31741	
Estimate Number : 10804	
P.O. Number :	Part Number : D35371
This Issue : 11/04/2007 S.O. No. :	Drawing Number : CUSTOM-H/D WELDS
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 13/04/2007 Qty: 18 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



(18x)

Comment: HAND FINISHING RESOURCE #1

PULL FROM STOCK

18 X D3537-1 B

31741 B30757

REMOVE PAINT WITH PAINT STRIPPER

M.L. 07/04/11

2.0	D35371	WEARPAD
-----	--------	---------



(18x)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)

WEARPAD

M.L. 07/04/11

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



(18x)

Comment: LARGE FABRICATION RESOURCE 1

CLEAN PROPERLY WITH A WIRE BRUSH

M.L. 07/04/11

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

07/04/11

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

WELD AS PER DRWG D3537 - MARKED UP BY SERGE

HEAVY DUTY HARD FACING

A7560/3-2 B 1072755

FC 07 04 12 (18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/04/2007 8:57:10 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D3537-1

Job Number: 31741

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

07/04/12

18

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

REPAINT GREY SANTEX PER QSI 005

M19720

m.r

07/04/12

18x

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

4 07-04-12

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

RESTOCK USING NEW B/N

USE FOR TUBES - 30967A & 30968A ONLY

u

07-04-13
sel
30967A
968A

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

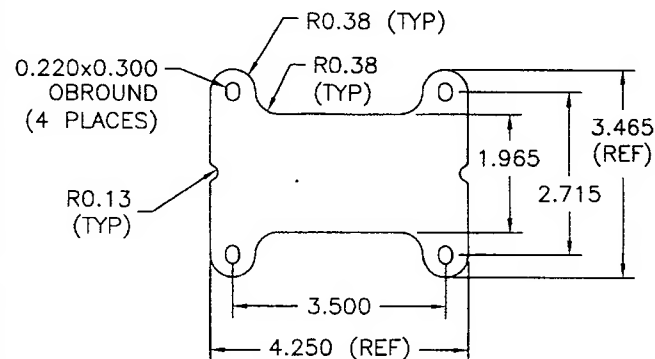
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

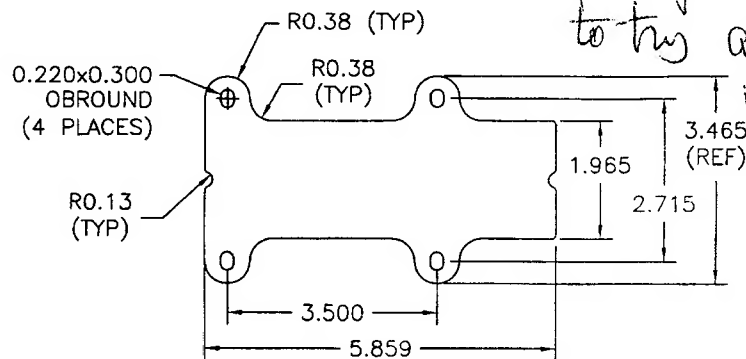
NOTE: Date & initial all entries

30967A
30968A

D3537-1F FLAT PATTERN

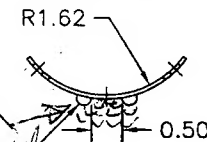


D3537-3F FLAT PATTERN



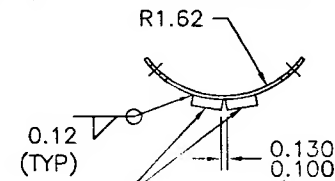
*Additional welds
are for customer
to try and give
US a feed back
as per Bill
Buckett,
Mh*

SECTION A-A



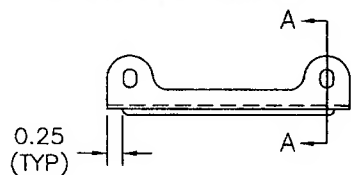
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

SECTION B-B

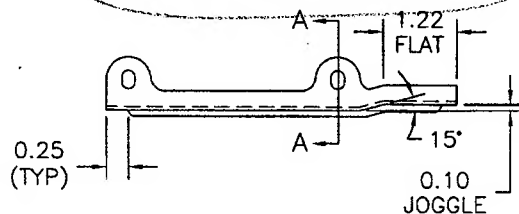


D3537-300
REMOVE POWDER
COAT FROM THESE
SURFACES

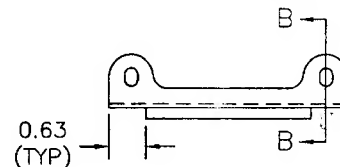
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



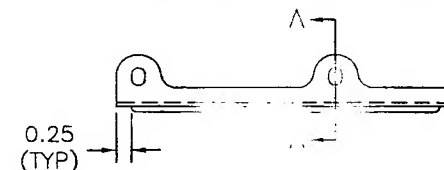
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



RELEASED

07.02.12

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE
(0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

A	06.11.06	NEW ISSUE	
DESIGN	CB	DRAWN	CB
CHECKED	PH	APPROVED	PH
DATE	06.11.06	TITLE	WEARPAD
		DRAWING NO.	D3537
		REV. A	
		SHEET 1 OF 1	
		SCALE	1:2

DART AEROSPACE USA, INC.
PORT HADLOCK, WA